

*Date: Thursday, 07/05/2009 11:42:54 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TURNING DETAIL FOR D2940-1
Job Number : 47786	
Estimate Number : 13237	
P.O. Number :	Part Number : DSK081
This Issue : 07/05/2009 S.O. No. :	Drawing Number : DSK081 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 45471	Material :
Written By :	Due Date : 28/05/2009 Qty: 10 Um: Each
Checked & Approved By : <u>09090507</u>	
Comment : est rev A. 08.03.13 new issue EC Est Rev:B 09-04-09 Now on Doosan Lathe JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6104007	Round Billet, 17-4
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Billet

BATCH: B45659ml 09/05/10

(5)

2.0	DOOSAN LATHE	DOOSAN LATHE
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**Comment:** DOOSAN LATHE

Turn blank as per Folio FA079

ml 09/05/10

(5)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINEml 09/05/10

(5)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECKml 09/05/11

(5)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock in Kanban

Location: _____

ml 09/05/11

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 07/05/2009 11:42:54 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TURNING DETAIL FOR D2940-1

Job Number: 47786

Part Number: DSK081

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/12 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47780
Description: Turning Detail for D2940-1		Part Number: DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype





				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.216	3.215	3.214	3.215	3.2125
B	4.946	4.966		4.954	4.954	4.954	4.955	4.956
C	0.718	0.738		.725	.727	.726	.725	.725
D	0.090	0.110		.104	.102	.104	.102	.104
E	3.564	3.584		3.575	3.577	3.575	3.575	3.575
F	0.022	0.042		.032	.032	.032	.032	.032
G	3.444	3.464		3.454	3.455	3.454	3.454	3.455
H	0.112	0.132		.119	.120	.120	.120	.122
I	2.170	2.190		2.176	2.178	2.176	2.177	2.178
J	4.451	4.471		4.463	4.464	4.465	4.464	4.463
K	0.413	0.433		.423	.423	.423	.423	.425
L	0.913	0.933		.926	.922	.920	.920	.923
M								
N								
O								
P								

Measured by: *onk* Date: 09/05/10

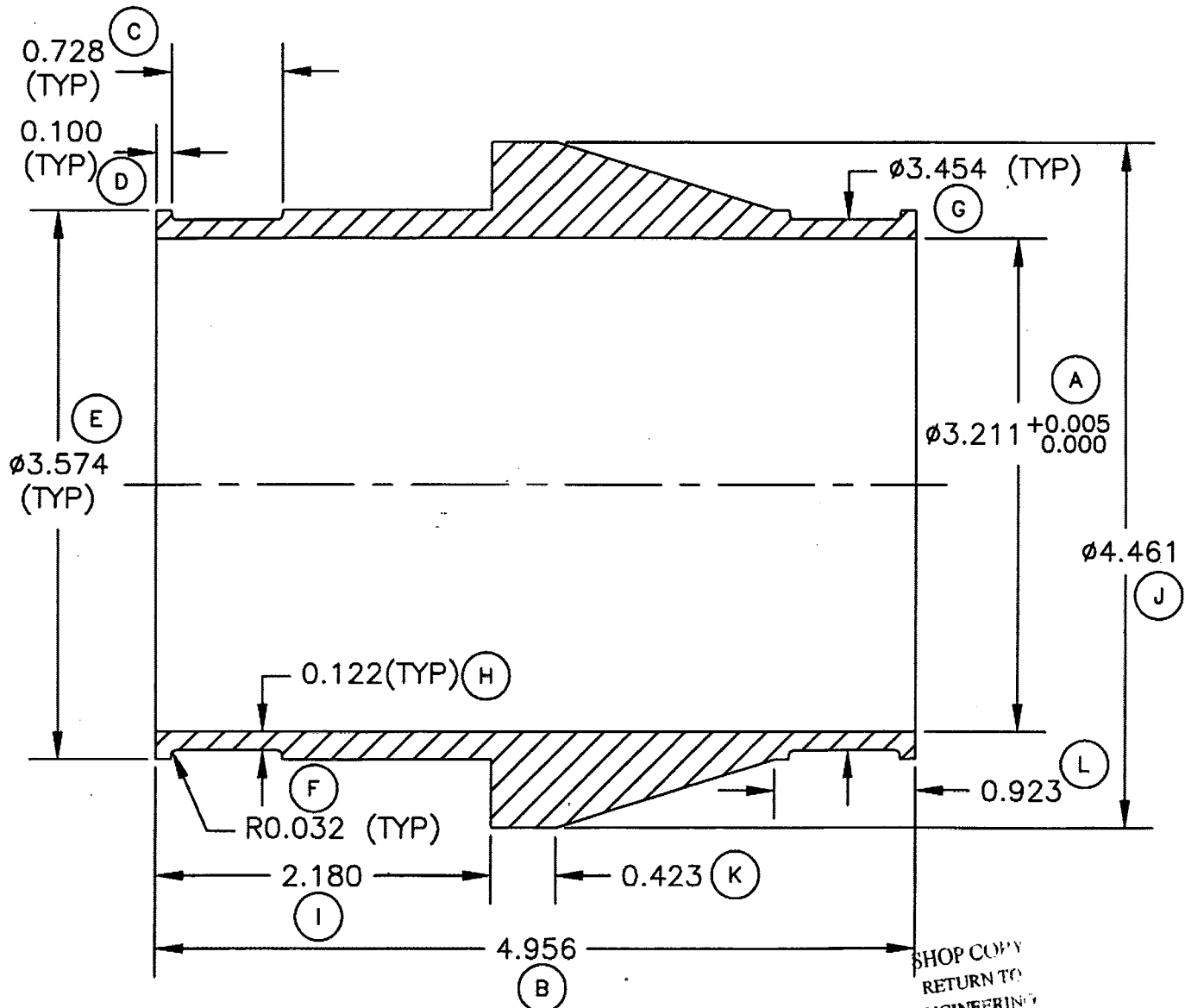
Audited by: *SA* Date: 09/05/11

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

DESIGN 		DRAWN BY 		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. DSK 081 REV. B SHEET 1 OF 1	
DATE 03.06.24			TITLE TURNING DETAIL FOR D2940-1 SCALE 1:1		
A	03.03.07		NEW ISSUE		
B	03.06.24		ADDED 4.956 DIMENSION		

RELEASED
03 07 01



D2940-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED EDITION
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 47286

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